



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

41232-200-001-002

Job Sheet 168395



Part No: 41232-200-001-002

Job Qty: 1 ea

Part Name: Step Actuator RH Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/14/17

Job Tracking No:

Due Date: 11/20/17

Created By: Linda Lacelle

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	1 Ea		11/18/17	0.00	0.00	Start Up Small Fab		
100	Small Fab	1 pcs		11/20/17	0.00	4.99	Small Fab		
110	QC	1 pcs		11/20/17	0.00	0.00	QC5		
120	Packaging	1 pcs		11/20/17	0.00	0.00	Packaging3		
130	QC21-SA	1 Ea		11/20/17	0.00	0.00	QC21		

Part Op Descriptions: 100 - 1- Assemble as per Dwg 41232-200-001 2-Torque as per Dwg 41232-200-001

DAS
21
9-89

NOV 29 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	41232-200-002-001 F105453	1	16	0	0
	41232-200-002-003 F107899	1	13	0	0
	41232-200-002-005 F107898	1	17	0	0
	41232-200-005-003 S011735	2	2	0	0
	AN3-22A F110998	1	13	0	0
	AN315-4R FM128978	1	76	0	0
	AN842-4D FM122170	1	14	0	0
	D3975-042 F61799	1	9	0	0
	MS16996-23 F112492-40	1	361	0	0
	MS20822-4 FM 26275	1	2	0	0
	MS21042L3 S000676	1	1,160	0	0
	NAS1149D0363J F111332	2	501	0	0
	NAS1149D0463J S014303	2	1,149	0	0
	S-1455 F111342	1	45	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S014334



Step Actuator RH Assembly

PART NO:
Revision:
Operation:
Change No:

41232-200-001-002

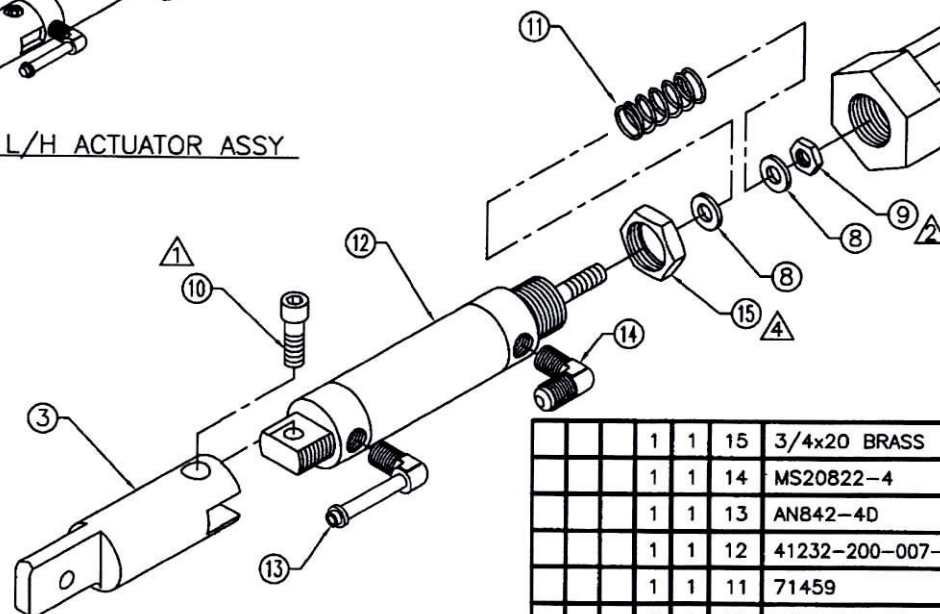
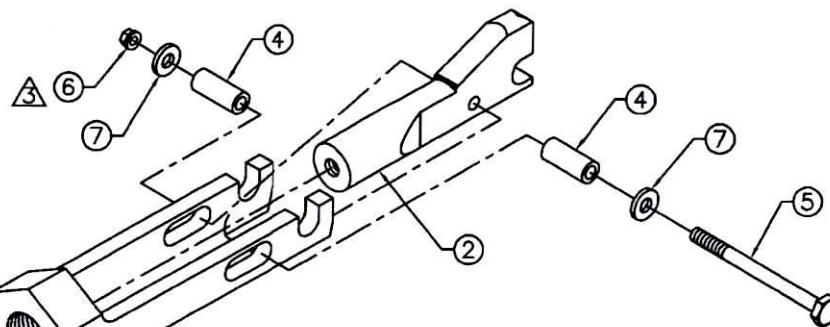
Start up Operation

Mfg Date: 11/27/17

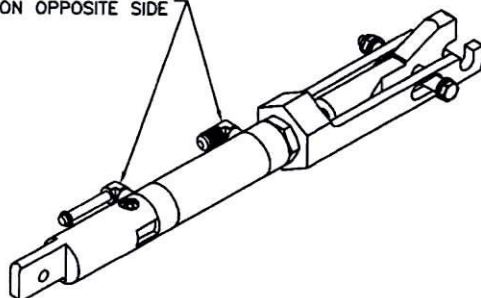
Job No: 168395

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Hawkesbury, ON K64 1K7
CANADA
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www.dartaerospace.com

-001 L/H ACTUATOR ASSY



INSTALL ITEM #12
ON OPPOSITE SIDE



-002 R/H ACTUATOR ASSY

-  TORQUE 80-100 IN.-LB.
 TORQUE 20-25 IN.-LB.
 TORQUE 50-75 IN.-LB.
 TORQUE 50-75 IN.-LB.

NOTES:

			1	1	15	3/4x20 BRASS	CYLINDER NUT				
			1	1	14	MS20822-4	ELBOW				
			1	1	13	AN842-4D	ELBOW				
			1	1	12	41232-200-007-001	CYLINDER				
			1	1	11	71459	SPRING				
			1	1	10	MS16996-23	CAP SCREW				
			1	1	9	AN315-4R	NUT				
			2	2	8	AN960JD416	WASHER				
			2	2	7	AN960JD10	WASHER				
			1	1	6	MS21042-L3	NUT				
			1	1	5	AN3-22A	BOLT				
			2	2	4	41232-200-005-003	SPACER				
			1	1	3	41232-200-002-005	PIVOT ARM				
			1	1	2	41232-200-002-003	LATCH				
			1	1	1	41232-200-002-001	TUBE				
						-002	R/H ACTUATOR ASSY				
						-001	L/H ACTUATOR ASSY				
			-002	-001	FIND NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE

NO. REQ'D PER ASSY			LIST OF MATERIAL												
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-002-001 1 41232-000-001			NEXT ASSEMBLY						Era Aviation, Inc.						



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Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: MS21042L3 Revision: Nut														
100	Receive Ea	S014299	168395	1 Ea	0		ST303		Stock	11/27/2017	Issue Container			
Operation Totals:		1		1	0									
Part Totals:		1		1	0									
Totals:		1		1	0									

Plex 1/8/2018 10:56 AM Dart.Boucher.Sylvie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								